

Date: Wednesday, 10/06/2009 10:33:58 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: RIB		
Job Number	: 48450			Part Number	: D22217		
Estimate Number	: 13675			Drawing Number	: D2221 REV H (PG.5)		
P.O. Number	:			Project Number	: N/A		
This Issue	: 10/06/2009	S.O. No.	:	Drawing Revision	: H		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: LARGE FAB ASSY	Due Date	: 16/06/2009		
Previous Run	: 48201			Qty:	4	Um:	Each
Written By	:						
Checked & Approved By	: <u>JUL 09 A-10</u>						
Comment	: Est Rev:A New Issue 08-12-02 DD verified by:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W		
		Comment: Qty.: 4.8344 f(s)/Unit Total : 19.3376 f(s) 304 SQ Tube .75x.75x.065W batch: <u>M112051</u>		SAP 09-06-19 (4)
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1		
		Comment: LARGE FABRICATION RESOURCE 1		
		✓ 1- Cut as per dwg D2221 ✓ 2- Deburr and remove identification markings on tube		SAP 09-06-22 (4)
3.0	QC5	INSPECT WORK TO CURRENT STEP		
		Comment: INSPECT WORK TO CURRENT STEP		SAP 09-06-22 (4)
4.0	PACKAGING 1	PACKAGING RESOURCE #1		
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>WG</u>		SAP 09-06-22 (4)
5.0	QC21	FINAL INSPECTION/W/O RELEASE		
		Comment: FINAL INSPECTION/W/O RELEASE		09/06/23 (4)
Job Completion				 MF 09-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

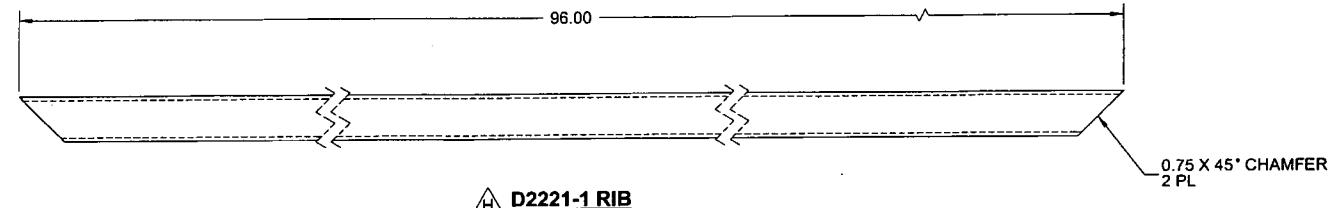
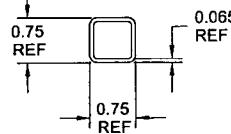
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

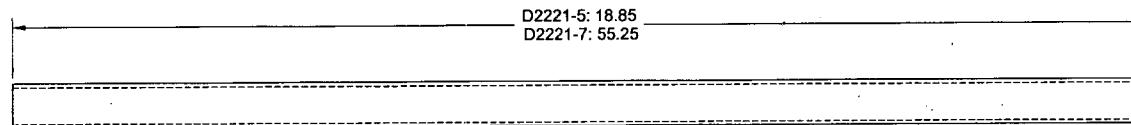
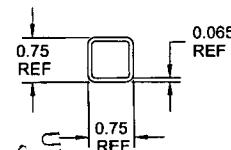
8 7 6 5 4 3 2 1

D



D2221-1 RIB

C



D2221-5/7 RIB

B

NO. WORKS 50
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
 REF. DART SPEC. M304TS0.750W0.065
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 8) WEIGHT:D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

RELEASED
06/11/16 MWD

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ASS</i>	DRAWING NO.	
MFG. APPR.	<i>ND</i>	REV. H	
APPROVED	<i>MWD</i>	D2221	SHEET 5 OF 5
DE APPR.	<i>ND</i>	TITLE	SCALE
DATE	08.09.18	BASKET BASE ASSEMBLY (350) NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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